

Work Order ID 110909

January-08-14 12:39:46 PM

110909

Page 1

Item ID: D4406-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Wearplate Assembly

Start Date: 1/08/14 Start Qty: 4.00

Cust Item ID:

Required Date: 1/08/14 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-01-09 Tooling: _____

Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4406

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

304.050

Memo

1-Cut as per dwg D4406-1

prog rev: Cdwg rev: C

2-Deburr if required

0.00

8 2 14-3-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

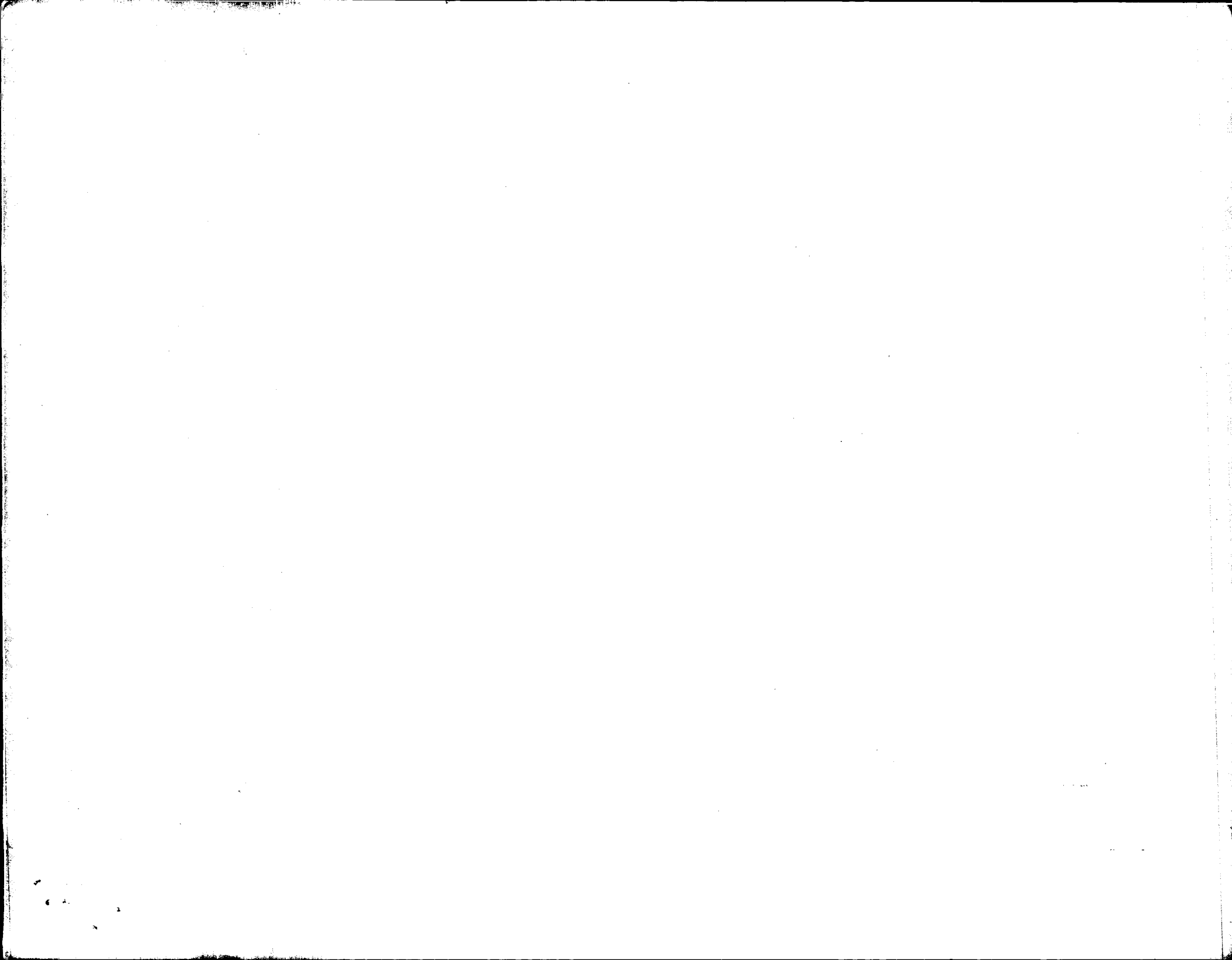
QC

Quality Control

Memo

0.00

8 2 14-3-28



Work Order ID 110909

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Page 2

Item ID: D4406-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Wearplate Assembly
 Start Date: 1/08/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

0.00

0.00

0.00

0.00

130

130

Small Fab

Small Fab

Memo

Form as per dwg D4406

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

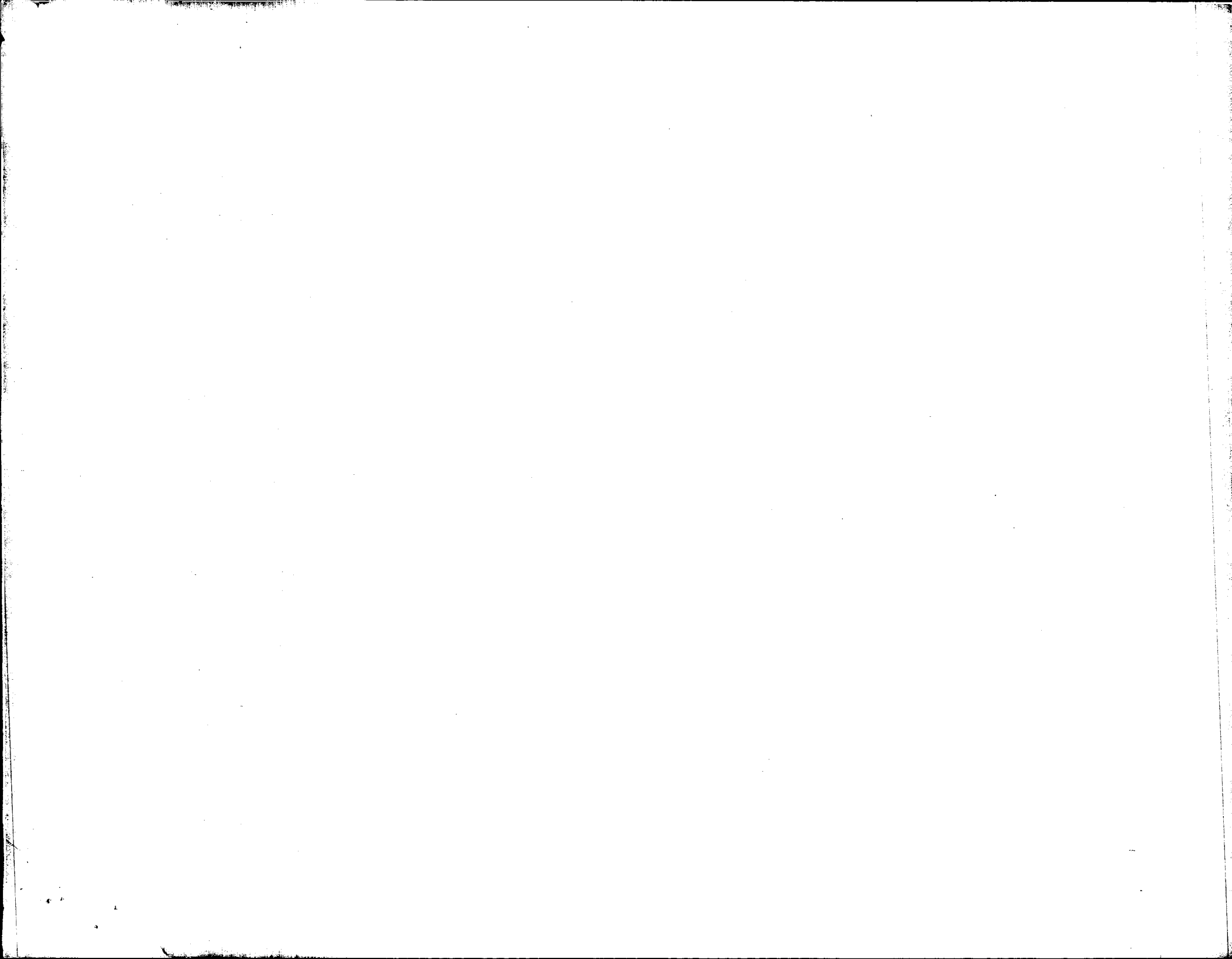
SNF
14/3/27

8

8x

8

DAS
36
9-89
14/03/31



January-08-14 12:39:46 PM

Item ID: D4406-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Wearplate Assembly

Start Date: 1/08/14 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/08/14 **Req'd Qty:** 4.00 ***/***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

0.00

Large Fab

Memo

Weld bar as per dwg

A/R 2059b hardcoat Batch#: M127456

Weld bar to wearplate as per dwg

A/R s.s. rod Batch #: mid0854

160

QC9- Inspect visual per QSI004- Fusion Welds	0.00
--	------

0.00

160

Memo

0.00

OC

Quality Control

165

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

165

Memo

0.00

QC

Quality Control

x4 14-04-09 MAC

④ 14.04.09 DAS
9
9-89

④ 14.04.09

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Page 4

Item ID: D4406-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Wearplate Assembly
 Start Date: 1/08/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170						4	0	0	As
Small Fab	Memo	0.00							14-4-10
Small Fab	Apply coating as per dwg D4406								
	127716								
180		0.00							
180						4			
QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
190		0.00							
190						x4	0	0	14/08/10
Packaging	Identify as per dwg & Stock Location: FP-002	0.00							
Packaging	Memo	0.00							

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Page 5

Item ID: D4406-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Wearplate Assembly

Start Date: 1/08/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 1/08/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

14-4-1414-04-14

Picklist Print

January-08-14 12:39:46 PM

Page 1

Work Order ID: 110909

Parent Item: D4406-041

Parent Item Name: Fwd Wearplate Assembly

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD IPP rev B 12.02.06 as per dwg
revPB1 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4407-1 Bar		Manufactured	No			150	Each	4.0000	2	8			
----------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

B 113630 ~~113630~~ x4

Location

Loc Qty

Loc Code

WA001

4

103299

4

8

14-04-09 MAL

M304S18GA

Purchased

No

304/316 .050 Sheet

100 sf

157.0000

3.5

15

EL 14.3 27

Location

Loc Qty

Loc Code

MAT019

136

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

79

MAT020

21

124029

2

M126098

19

M128254

x 22.5

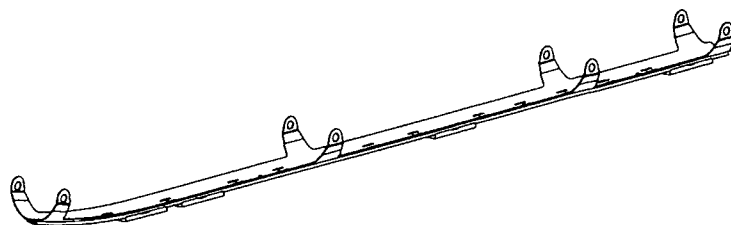
DART AEROSPACE LTD		Work Order:	110909
Description: Plate		Part Number:	D4406-1
Inspection Dwg: D4406 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

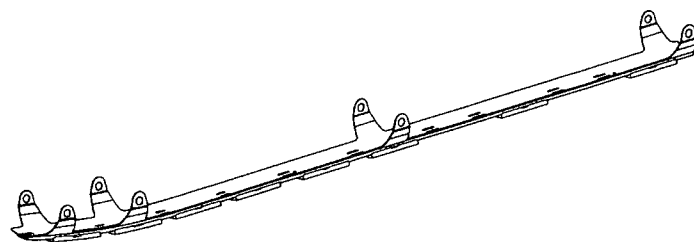
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.561	+/-0.010	0.561	✓		V JRM05	
0.30	+/-0.030	0.301	✓			
1.00	+/-0.030	1.004	✓			
0.13	+/-0.030	0.125	✓			
1.77	+/-0.030	1.773	✓			
7.203	+/-0.010	7.203	✓			
7.80	+/-0.030	7.777	✓			
8.00	+/-0.030	8	✓		JRM07	
6.94	+/-0.030	6.94	✓			
4.00	+/-0.030	4	✓			
36.00	+/-0.030	36	✓			
66.06	+/-0.030	66.06	✓			
2.43	+/-0.030	2.43	✓			
7.067	+/-0.010	7.067	✓			
7.77	+/-0.030	7.77	✓			
12.745	+/-0.010	12.745	✓			
37.308	+/-0.010	37.308	✓			
63.734	+/-0.010	63.734	✓			
0.050	+/-0.010	0.05	✓			
0.188	+0.005/-0.001	0.190	✓			
6.38	+/-0.030	6.38	✓			
4.25	+/-0.030	4.25	✓			
6.45	+/-0.030	6.45	✓			
12.13	+/-0.030	12.13	✓			
4.00	+/-0.030	4.00	✓			

Measured by:	EL	Audited by:	21 9-289	Preliminary Approval:	
Date:	14-3-27	Date:	14/3/27	Date:	

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-041	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	
C	13.05.27	Dimensions revised per Dwg Rev C	KJ	



D4406-041 FWD WEARPLATE ASSY



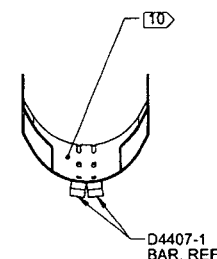
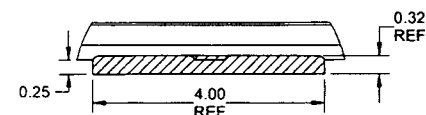
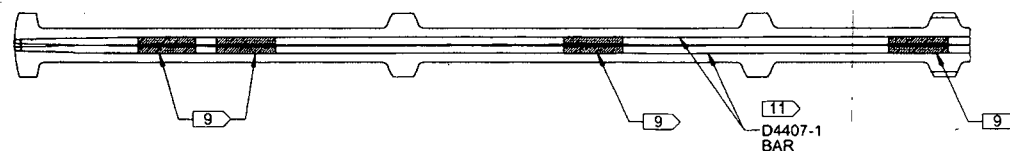
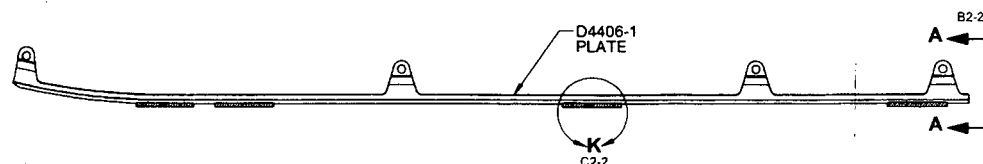
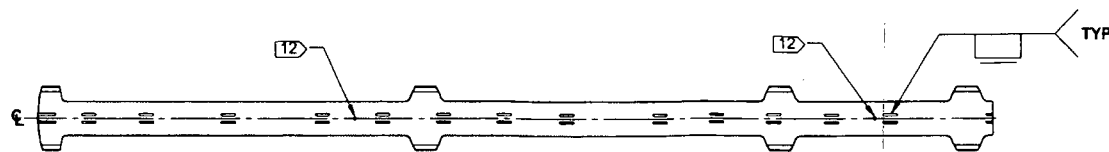
D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

110909 MJS
14-01-09

RELEASED
2013-03-21

C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED. SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031).	AJS	13.03.11
B	REVISE BILL OF MATERIAL; ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3; MODIFY DETAIL E & F (ZN B5-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D4406	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.03.11	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4406-041 FWD WEARPLATE ASSY

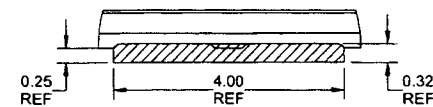
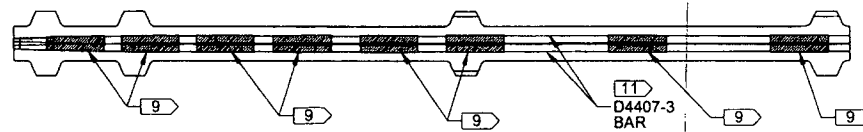
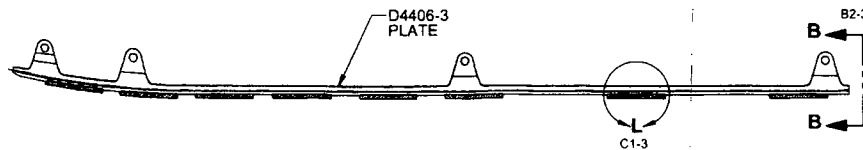
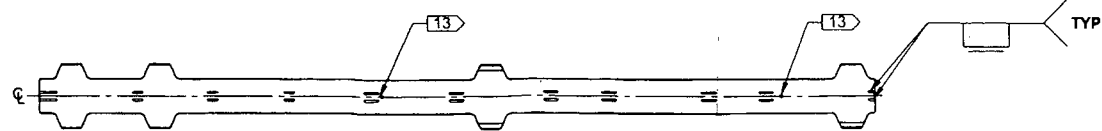
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

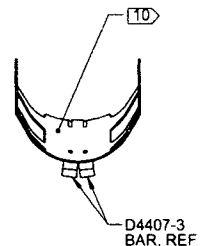
A.P.
14.04.10
- 4715A

RELEASED
2013-03-21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	14	D4406	SHEET 2 OF 6
APPROVED	14	TITLE	SCALE
DE APPR.	14	WEARPLATE ASSY	NTS
DATE	13.03.11	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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DETAIL L C4-3
WELD BUILDUP DETAIL 8 PL
SCALE 4X



SECTION B-B C3-3
SCALE 2X

D4406-043 AFT WEARPLATE ASSY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 8.85 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
 - 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
 - 13) TRANSFER $\phi 0.188$ HOLES FROM D4406-3 TO D4407-3
 - 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

RELEASED
2013-03-21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4406	SHEET 3 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	WEARPLATE ASSY	NTS
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